

**Work Order ID 83136**

Friday, April 13, 2012 10:10:10 AM

**\*83136\***

Page 1

Item ID: D4005-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Restaint Beam

Start Date: 4/13/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: Date: 12-04-13 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4005

B

100

0.00

**\*100\***

Purchasing

Purchasing

Memo

Issue P/O: 10714  
Purchase part as per Dwg D4005  
Possible Supplier: GFI  
Material release note required

0.00

110

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*110\***

Packaging

Packaging

Memo

0.00

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Quality Control

Memo

0.00

12-04-13Supp 10 (6)(46)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83136**

Friday, April 13, 2012 10:10:10 AM

**\*83136\***

Page 2

Item ID: D4005-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Fwd Restaint Beam  
Start Date: 4/13/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 4/25/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				6	26	12515	
133 <b>*133*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				6X	0		M/L 12/05/16
135 <b>*135*</b> Powdercoat Powder Coating	Gloss Grey (4.3.5.15) per QSI 005 4.3  Memo Start Time: 12:00 Oven Temperature: 320°F Finish Time: 12:30	0.00  0.00				6X	0		M/L 12/05/16

M118533

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Friday, April 13, 2012 10:10:10 AM

**\*83136\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**\*6\***

**Start Date:** 4/13/2012      **Start Qty:** 6.00

**Cust Item ID:**

**Required Date:** 4/25/2012      **Req'd Qty:** 6.00

**\*6\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

**\*140\***

0.00

6 4 BL 25-16.

0.00

**\*150\***

0.00

## Packaging

Lex \_\_\_\_\_ \$  
12-5-17

0.00

**\*160\***

0.00

## Quality Control

12/5/17 *[Signature]*  
mf  
12-05-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, April 13, 2012 10:10:14 AM

Page 1

Work Order ID: 83136

**\*83136\***

Parent Item: D4005-3

**\*D4005-3\***

Parent Item Name: Fwd Restaint Beam

Start Date: 4/13/2012

Required Date: 4/25/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 09.12.23 new Issue Prelim EC verified by: DD IPP Rev:B  
10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 12.03.07 as  
per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4005-3P		Purchased	No			110	Each	0.0000	1	6			
<b>*D4005-3P*</b>									<b>**</b>				
Fwd Restaint Beam													

*P4/10/10 (6)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

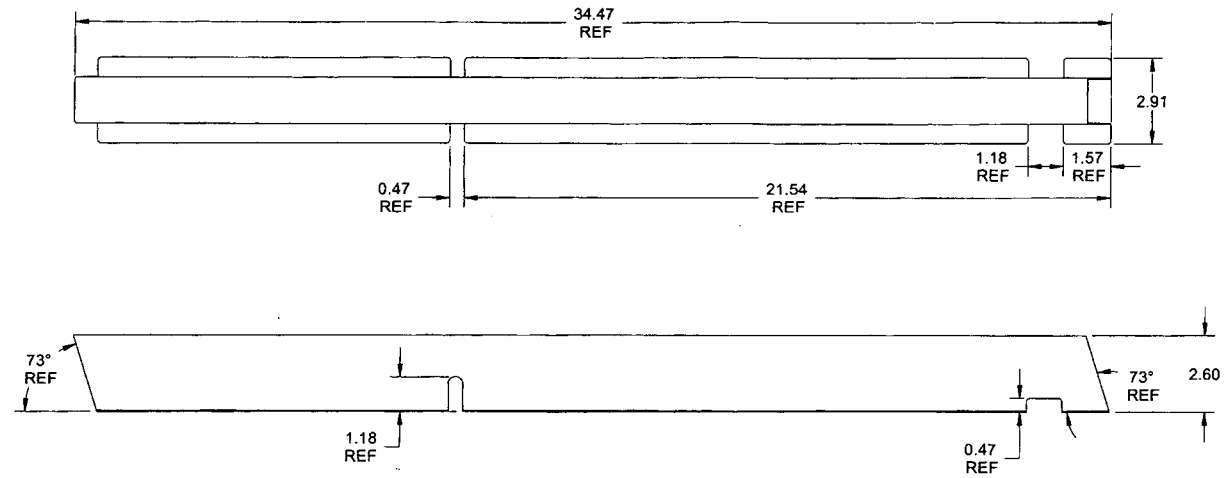
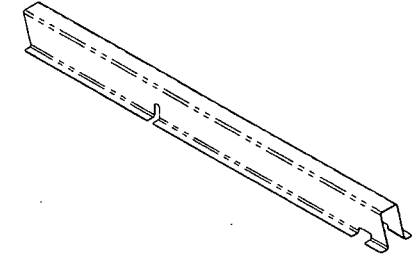


SHOP COPY

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83134

*12-04-13*

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-3	JCA-M47-2-05



**D4005-3 FORWARD RESTRAINT BEAM**

RELEASED  
2012-03-02  
*ND*

- NOTES:
- 1) MATERIAL: MADE FROM D4005-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 1.01 lbs

DESIGN	<i>BE</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>BE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BE</i>	DRAWING NO. <b>D4005</b>	REV. B
MFG. APPR.	<i>BE</i>		SHEET 4 OF 15
APPROVED	<i>ND</i>	TITLE <b>RESTRAINT</b>	SCALE NTS
DE APPR.	<i>ND</i>		
DATE	11.06.06		

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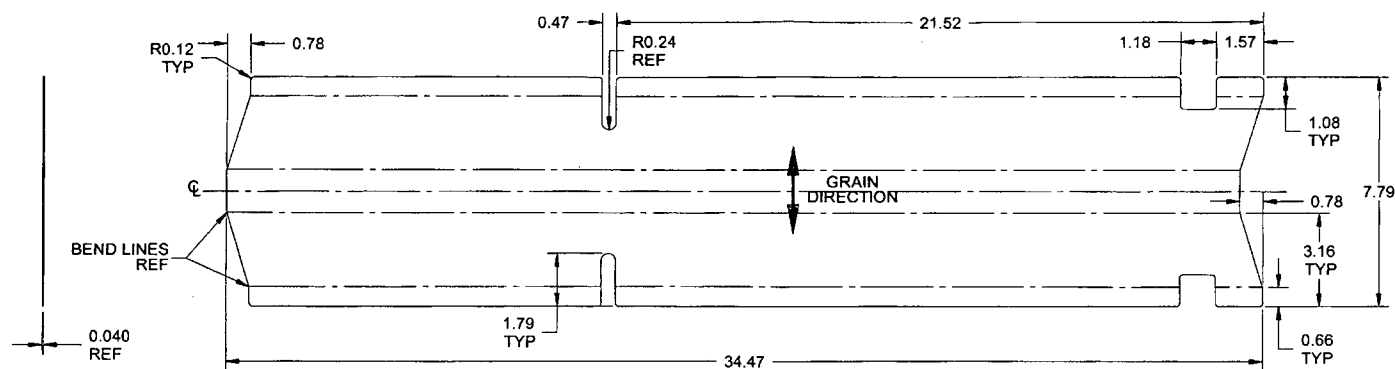
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries.



**D4005-3F FLAT PATTERN**

83134

RELEASED  
2012-03-03  
JMD

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4005</b>	SHEET 5 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>RESTRAINT</b>	NTS
DATE	11.06.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO16716

Purchase Order Date 4/13/2012

PO Print Date 4/13/2012

Page Number 1 of 1

Order From : VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

Contact Name	Buyer	Brigitte Golden
Vendor Phone 514 630 4877	Requisition Nbr	
Vendor Fax 514 630 4849	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
4/13/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D4007-3P		Support	5/10/2012 Yes	6.00 Each		\$111.8682	\$671.21
		Special Inst:	As per DWG: D4007 Rev: A B83137				
D4005-3P		Fwd Restaint Beam	5/10/2012 Yes	6.00 Each		\$99.2780	\$595.67
		Special Inst:	As per DWG: D4005 Rev: B B83136				

PO Total: \$1,266.88

MATERIAL CERTIFICATION  
REQUIRED UPON DELIVERY

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 4/13/2012



180 AVENUE LABROSSE  
POINTE-CLAIRE, QC, CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



## BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON	PAGE
JR - DY	MO - MO	AN - YR	SHIPPING MEMO NO.	
08	05	12	0487234	1/1

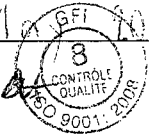


VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
DART		GFI-0299	0248581	PO16716
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.			DESCRIPTION
6	D4005-3P			FWD RESTRAINT BEAM
CERTIFICATE OF CONFORMANCE REQ				
<p>MFG. JOB# <u>J0248581-001</u> QTY <u>6</u> pcs.</p> <p>DUE DATE: <u>10 May 2012</u></p> <p></p>				

EXPÉDITEUR  
SHIPPER

N° DE BON DE LIVRAISON  
SHIPPING MEMO NO.



RECU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 2 OUR JOB NO J0248581 SHIPPING MEMO 0487234

ITEM QUANTITY PURCHASE ORDER PART NUMBER REV NAME DWG ISSUE

6 PCS PO16716 D4005-3P FWD RESTRAINT BEAM B

MATERIAL SUPPLIED BY MAT. REL. NO.

AL 2024-T3 SAMUEL / KAISER ALUMINUM 524292A0  
(AMS-QQ-A-250/4)

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2	REF. GFI MANUFACTURING JOB NUMBER J0248581-001 (6 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 09 MAY 2012

G.F.I. Q.C. REP Arthur Ha





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2008 + AS9100B

## LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: June 30, 2011

**Company Name:** GFI Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe-Claire Qc  
**Zip Code:** H9R 1A1

**# du client:** 0078734  
**Customer's order #:**

**# de commande SSMQ:** 115322  
**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	1	.040" X 48" X 144"	2024 T3	AMS-QQ-A-250/4	524292A0

Bien à vous,  
Yours truly,



## SHIP TO:

SAMUEL BAIE D'URFE(SHIP TO)  
21525 CLARK-GRAHAM  
BAIE D'URFE, PQ, CA H9X 3T5

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number

4212181

## SOLD TO:

SAMUEL LAVAL  
2225 FRANCIS HUGHES  
LAVAL, PQ, CA H7S1N5

CUSTOMER PO NUMBER: C63137		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP RUN/LOAD: 101940/2		GOVT CONTRACT NUMBER:	
KAISER ORDER NO: 1107049		LINE ITEM: 2	SHIP DATE: 8-DEC-2010		ALLOY: 2024	CLAD: BARE	TEMPER: T3	PRODUCT DESCRIPTION: HT Flat Sheet	
WEIGHT SHIPPED: 21591 LB		QUANTITY: 765 PCS EST.		B/L NUMBER: 2029943		GAUGE: 0.0400 IN		DIAMETER/WIDTH: 48.000 IN	
								LENGTH: 144.000 IN	

### Certified Specifications

AMS 4037/RevN  
CMMP 019/RevD

AMS-QQ-A-250/4/RevA  
CMMP 025/RevT

ASTM B 209/Rev07

Test Code: 1504

### Test Results

Lot: 524292A0 Cast 515

Drop 58

Ingot 1

D479256-7

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	67.6 : 68.1 (466 : 470)	45.2 : 45.2 (312 : 312)	15.0 : 16.3

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.07	0.16	4.4	0.55	1.3	0.01	0.13	0.01	0.01	0.00	TOT 0.03

Lot: 524353A0 Cast 515

Drop 58

Ingot 3

D479253-4

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	66.5 : 68.3 (459 : 471)	44.5 : 45.0 (307 : 310)	16.9 : 18.0

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.07	0.16	4.4	0.55	1.3	0.01	0.13	0.01	0.01	0.00	TOT 0.03

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4212181

Lot: 524428A0 Cast 515

Drop 57

Ingot 1

DYAGAS2 - 5 - 8

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	67.6 : 67.6 (466 : 466)	45.2 : 45.4 (312 : 313)	15.8 : 16.3

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.07	0.16	4.5	0.56	1.4	0.01	0.10	0.01	0.01	0.00	TOT 0.04

### ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

### ORDER COMMENTS

MAX HEIGHT 12" SKIDDED

### CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-1(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTIRE ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

*Bill Poy*